

Date: Wednesday, 04/06/2008 12:36:40 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: PROP ARM		
Job Number	: 39696					
Estimate Number	: 10931					
P.O. Number	:			Part Number	: D2187	
This Issue	: 04/06/2008		S.O. No. :	Drawing Number	: D2187 REV A1	
Prsh Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type :	Drawing Revision	: A1	
Previous Run	:			Material	:	
Written By	:			Due Date	: 11/06/2008	
Checked & Approved By	: <u>JUL 08-6-04</u>			Qty:	10	Um: Each
Comment	: Est E 02.06.11 Added finish RF					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0500W035	304 RD Tube .500 x .035W	
		Comment: Qty.: 3.1500 f(s)/Unit Total : 31.5000 f(s) Material: .0500 Dia X .035 wall 304/316 M304TR0500W035 Seamless stainless steel tubing	
		Batch No: <u>M108215</u>	<u>SB 08/06/04</u>
2.0	BRAKE NC	NC BRAKE	
		Comment: BRAKE NC Punch per Dwg. D2199 and spec control Dwg. D2727	
			<u>SB 08/06/04</u>
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr Drill hole open 0:404"AE as per Dwg. D2187 (one end only)	
			<u>E08/06/10</u>
4.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	<u>S 08/06/10 (x10)</u>
5.0	POWDER COATING	POWDER COATING	
		Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3	
		START TIME: <u>3:40 pm</u>	
		OVEN TEMPERATURE: <u>400 °F</u>	
		FINISH TIME: <u>4:10 pm</u>	
			<u>08/06/10</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 04/06/2008 12:36:40 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PROP ARM

Job Number: 39696

Part Number: D2187

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FL 08/06/11 (10)

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57026

RE 08/06/11 (10)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/12 (10)

Job Completion



MF 08-06-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

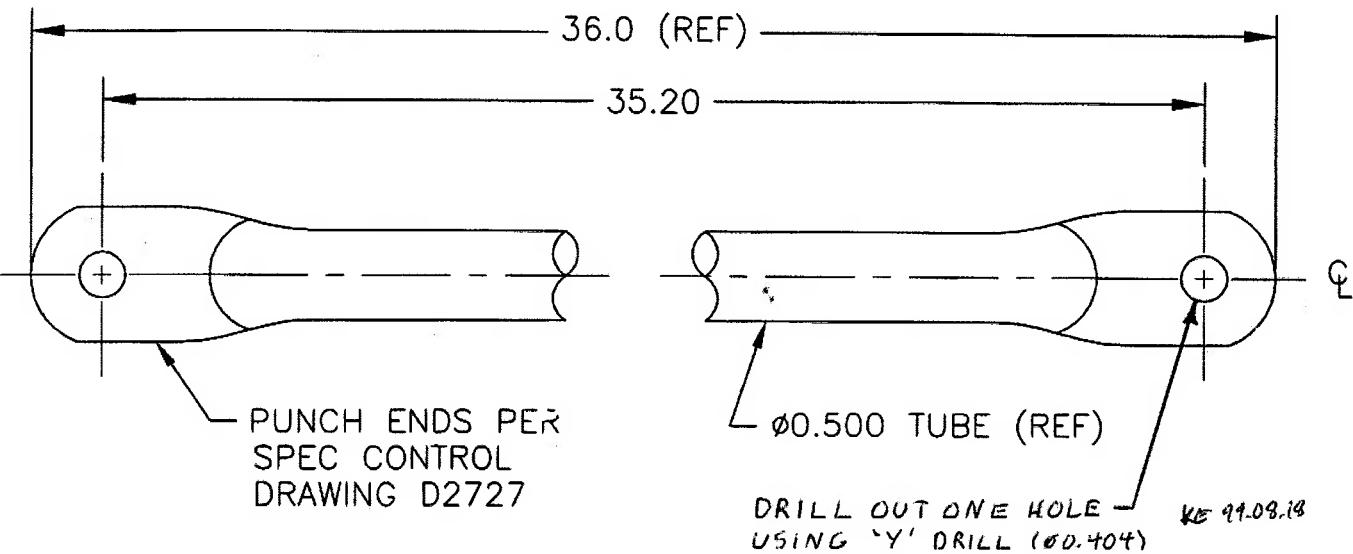
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>KE</i>	DRAWN BY <i>KEF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>DD</i>	APPROVED <i>CP</i>	DRAWING NO. D2187	REV. A SHEET 1 OF 1
DATE 98.04.28		TITLE PROP ARM	SCALE NTS
A	98.04.28	NEW ISSUE	
A1	<i>CP</i>	02.05.22	ADD FINISH

RELEASED
48/05/05 KE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31690

NOTE: MAKE PER TEMPLATE DT8118

MATERIAL: AISI 304/316 STAINLESS STEEL TUBE, Ø0.500 x 0.035 WALL

FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI QDS. 4.3 (A)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

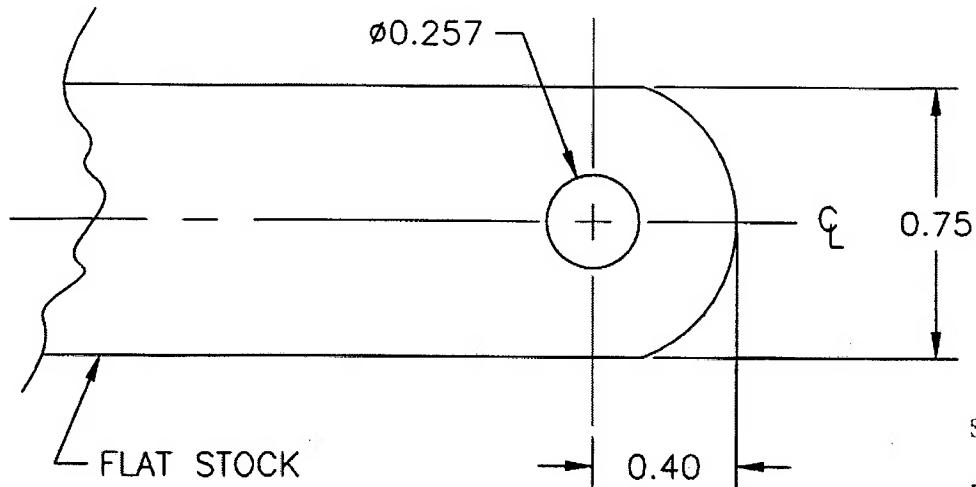
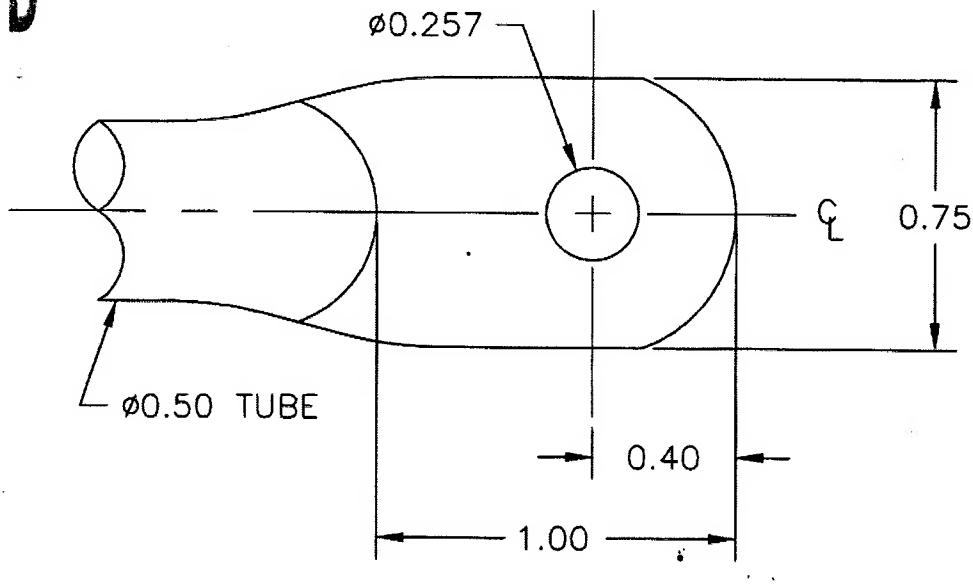
NOTE: Date & initial all entries

DART

DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>DMY</i>	APPROVED <i>CA</i>	DRAWING NO. D2727
DATE 97.11.24		REV. A SHEET 1 OF 1
		TITLE PUNCH DT8012 SPEC CONTROL
A	97.11.24	SCALE 2:1
A1	HCP 01.12.20	ADD TOLERANCE NOTE

SPECIFICATION CONTROL DRAWING FOR PUNCH DT8012

RELEASED
98/03/06 KE



NOTE: TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

A1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries